

Work Order ID 65757

January 25, 2011 6:59:05 AM



Page 1

Item ID: D2274

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 1/25/11 Start Qty: 250.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 250.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00



SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

x 28 11.1.25 250

11.1.26 250

11.1.26 250

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 1/25/11 Start Qty: 250.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 250.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|----------------|--------------|---------------|---------------|------------------|----------------|
| 130 QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | B.A 11/01/27 | | 250 | 0 | | |
| 140 Small Fab Small Fab | Small Fab Memo Tumble□Deburr any rough edges after tumbling | 0.00 0.00 | | | | | | B11-1-28 | 250 |
| 150 HandFinish Hand Finishing | Chemical Conversion Coat per QS1005 4.1 Memo | 0.00 0.00 | | => JH 11/01/31 | | 250 | 0 | | |

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NOTE: Date & initial all entries

Work Order ID 65757

January 25, 2011 6:59:06 AM



Item ID: D2274

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 1/25/11

Start Qty: 250.00



Cust Item ID:

Required Date: 1/28/11

Req'd Qty: 250.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID,

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

250 BL 11-07-31.

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

11/1/31 250 SD

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/31 JG

CL 11/01/31

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NOTE: Date & initial all entries

Picklist Print

January 25, 2011 6:59:04 AM

Page 1

Work Order ID: 65757

Parent Item: D2274

Parent Item Name: Radius Block



Start Date: 1/25/11

Required Date: 1/28/11

Start Qty: 250.00

Required Qty: 250.00

Comments: IPP H: 00.05.18: Added inspection level 8 [EC]

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B00750X00.1 25 | | Purchased | No | | | 100 | f | 70.0243 | 0.0916 | 24.10526 | | | |



6061-T6 Bar .750 x .125



11.1.26

Location

Loc Qty

Loc Code

MAT

51

116406

51

MAT01

19.0243

113608

14.75

113680

1.4947

113719

2.7796

3.4704

14.7500

2.7796

21

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

65757

☒ **First Article** ☐ **Prototype**

100-02

11.1.26

d by

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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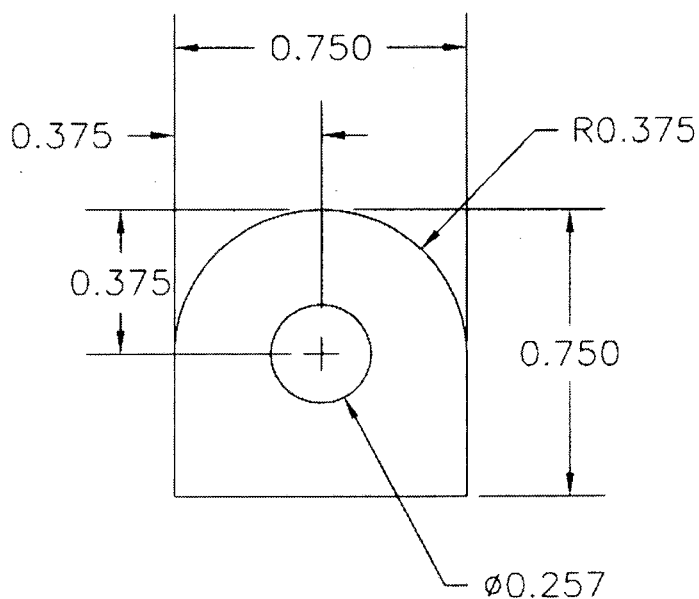
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NOTE: Date & initial all entries



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|----------------------|-----------------------|---|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>MP</i> | APPROVED <i>CS</i> | DRAWING NO. D2274 | REV. F SHEET 1 OF 1 |
| DATE 98.08.11 | | TITLE RADIUS BLOCK | SCALE 2:1 |
| A | 94.09.29 | NEW ISSUE | |
| C | 95.07.12 | RADIUS ENDS | |
| D | 97.03.24 | ADD MATERIAL SPECIFICATION | |
| E | 97.12.12 | ADD FINISH & TOLERANCE QSI | |
| F | 98.08.11 | R0.0 - 0.13 WAS R0.063 - 0.125 | |

RELEASED
98/08/19 KE



alv6757

EE 00.05.06
00.05.16
0.063 x 45° CHAMFER
R0.0 — 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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